

Date: Thursday, 12/15/2005 3:55:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 25248					
Estimate Number	: 10980					
P.O. Number	: N/A			Part Number	: D2808	
This Issue	: 12/15/2005	S.O. No.	N/A	Drawing Number	: D2808 REV A1	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: M1	Type	MACHINED PARTS	Drawing Revision	: A1	
Previous Run	: N/A			Material	: N/A	
Written By	<u>SEE COMMENT Below</u>			Due Date	: 12/22/2005	
Checked & Approved By	<u>SEE ABOVE DATE & USER</u>			Qty:	30	Um: Each
Comment	: Est Rev:D 02.03.07 Now turned in house NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
		Comment: Qty.: 0.0557 f(s)/Unit Total : 1.6695 f(s) 6061-T6 Round Bar .625" (M6061T6R0625) Batch: M18740	<i>ML 06/01/12 30</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL	
		1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit)	
		2-Deburr	<i>ML 06/01/13 30</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>ML 06/01/13 30</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>JL 06.01.13 30</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>SAD 06.01.18 30</i>
5.1	<i>Powder Coat Gloss White as per PART QSI 005 4.3</i>		
			<i>DL 06/02/19 30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CY06102120

(30)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 389

CY06102120

(30)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sat 06/02/21

(30)

DP 06/02/21

(30)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25248
Description: Spacer	Part Number:	D2808
Inspection Dwg: D2808	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

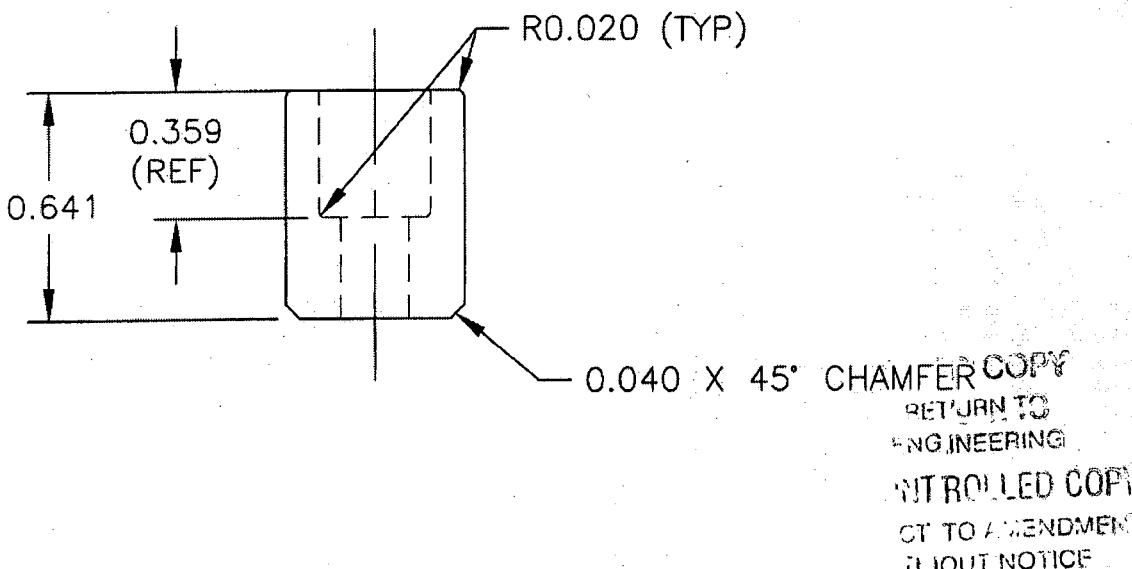
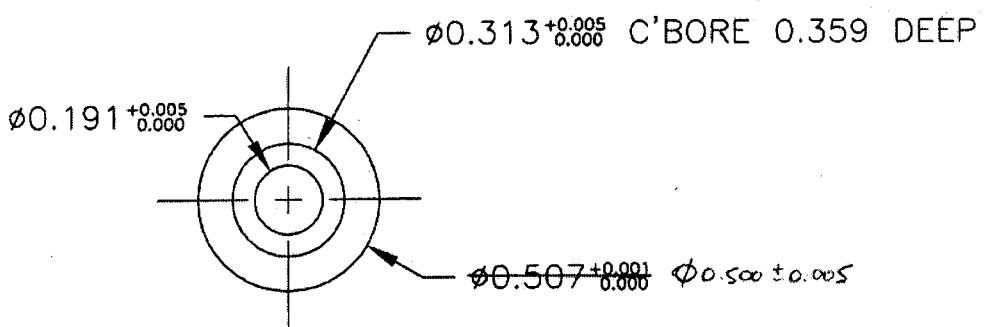
Measured by:	Tin	Audited by:	JL	Prototype Approval:	N/A
Date:	06/01/13	Date:	06/01/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	

DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2808	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.07		SPACER	2:1
A	00.11.07	NEW ISSUE	
A1	CP 01.04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
00.11.13 CP

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER
 BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
 MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 NO. 25248
 POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)
 OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3